

October 15, 2009 12:37:48 PM



Accept

**Setup Start**

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 15/10/2009 **Start Qty:** 6.00

**Cust Item ID:**

Required Date: 27/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start

**Approvals:**

Process Plan:

Date: 07/01/15

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

[illegible]

Work Order ID 52848

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Page 2

Item ID:	D2665-1	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Saddle, LH Fwd Aft Out 206					
Start Date:	15/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	27/10/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SF 09/11/29			6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	UMD 09/11/30			x6			
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11/21/09 Memo START TIME: 1:45 320 FINISH TIME: 2:45	0.00 0.00	BL 09-11-30			6			

OVEN TEMPERATURE:



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Item ID: D2665-1 Accept  Setup Start 
Revision ID: D Stop 
Item Name: Saddle, LH Fwd Aft Out 206
Start Date: 15/10/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 27/10/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>4</i>	<i>09/12/01</i>		<i>X6</i>	<i>0</i>		
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>5#436</i> Memo	0.00 0.00							<i>09/12/01</i> <i>6</i>
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>09/12/01</i> <i>MF</i> <i>MF 09-12-01</i>

Picklist Print

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Work Order ID: 52848

Parent Item: D2665-1RevD

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 15/10/2009

Required Date: 27/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003RevB		Manufactured	No			100	Each	0.0000	6.0000			

Saddle Billet, 7075

B46410 X6

SL 09/11/29

DART AEROSPACE LTD	Work Order: 52848
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.117	.118	.118	.118		
B	0.100	0.140		.128	.128	.125	.124		
C	1.125	1.145		1.135	1.136	1.137	1.137		
D	0.615	0.685		.660	.660	.660	.660		
E	0.240	0.260		.254	.253	.253	.256		
F	1.313	1.343		1.327	1.328	1.330	1.329		
G	0.210	0.230		.220	.222	.223	.223		
H	0.100	0.180		.125	.125	.125	.125		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.573	1.574	1.575	1.575		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.116	.113	.113	.113		
M	0.990	1.010		.993	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	.512		
O	5.990	6.010		6.003	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.798	.797	.797		
W	0.540	0.560		.550	.550	.551	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.923	.923	.922	.922		
AA	0.490	0.510		.503	.499	.501	.498		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>SL</u>
Date: <u>09/11/29</u>

Audited by: <u>LP</u>
Date: <u>09/11/29</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD		Work Order: 52747
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	3	4		
A	0.100	0.140		.119	.118				
B	0.100	0.140		.125	.125				
C	1.125	1.145		1.138	1.137				
D	0.615	0.685		.660	.660				
E	0.240	0.260		.251	.251				
F	1.313	1.343		1.326	1.325				
G	0.210	0.230		.221	.221				
H	0.100	0.180		.125	.125				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.576	1.575				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.113	.113				
M	0.990	1.010		1.000	1.000				
N	0.510	0.515		.512	.512				
O	5.990	6.010		6.002	6.002				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.314	.314				
S	0.315	0.322		.316	.316				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.797	.798				
W	0.540	0.560		.550	.550				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.923	.923				
AA	0.490	0.510		.500	.500				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JL
Date:	09/11/29

Audited by:	RF
Date:	09/11/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



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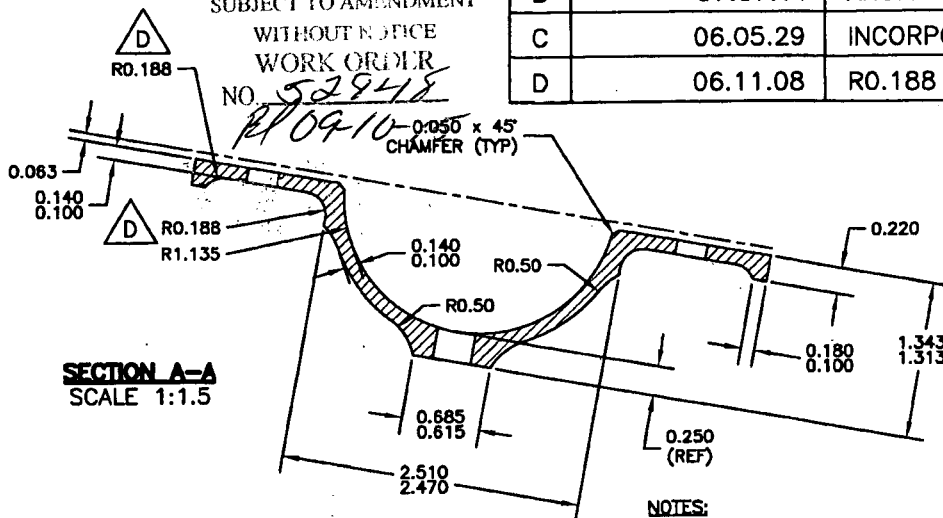
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *52848*
R10910

DESIGN	<i>A</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>A</i>	DRAWING NO. D2665
				REV. D SHEET 1 OF 1
DATE	06.11.08	TITLE	SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

RELEASED

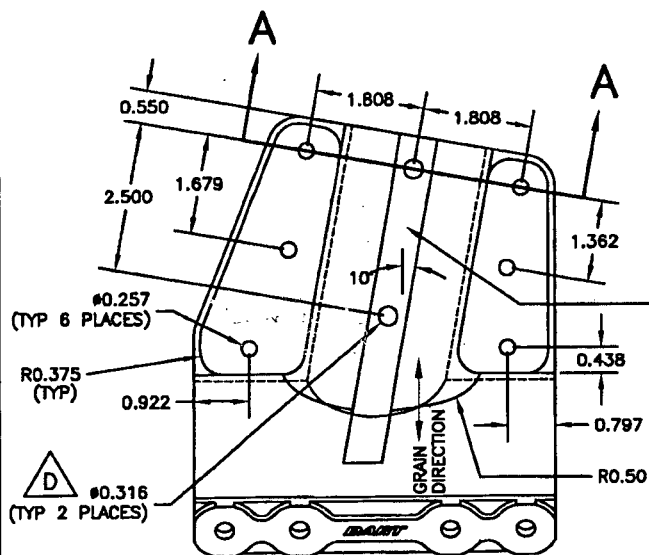
07.02.12 *A*

SECTION A-A
SCALE 1:1.5

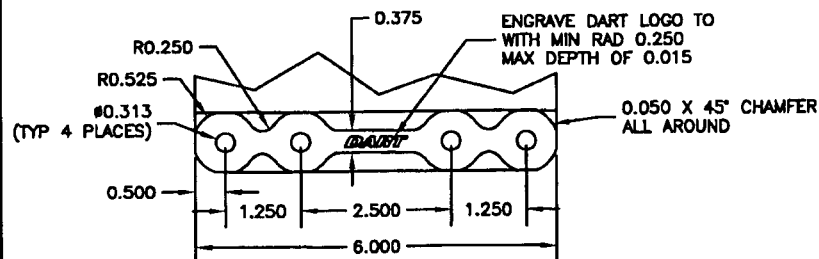
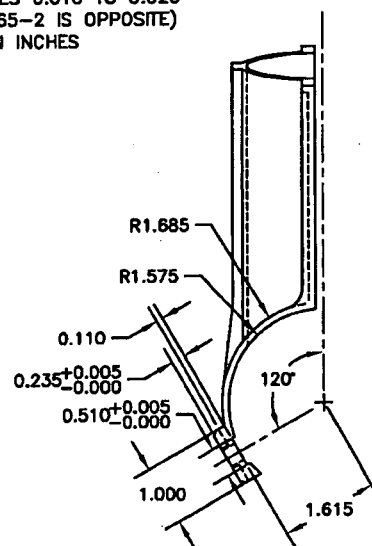


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

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